

Date: Monday, 31/03/2008 1:32:12 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLATE		
Job Number	: 38250		Part Number	: D32191		
Estimate Number	: 10425		Drawing Number	: D3219 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	31/03/2008	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	11	Type : SMALL /MED FAB	Due Date	07/04/2008	Qty:	40
Previous Run	: 37932		Um:	Each		
Written By	<i>Jean</i>					
Checked & Approved By	<i>108-03-31</i>					
Comment	: Est. A04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
		 Comment: Qty.: 0.1012 sf(s)/Unit Total : 4.0488 sf(s) 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: <u>106634</u> B 8-3-31
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev: <u>A</u> B 8-3-31 
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK 
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.

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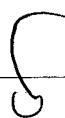


Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



counts
08/04/03

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 78

08/04/03

08/04/03

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/04/03

DART AEROSPACE LTD	Work Order:	38250
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

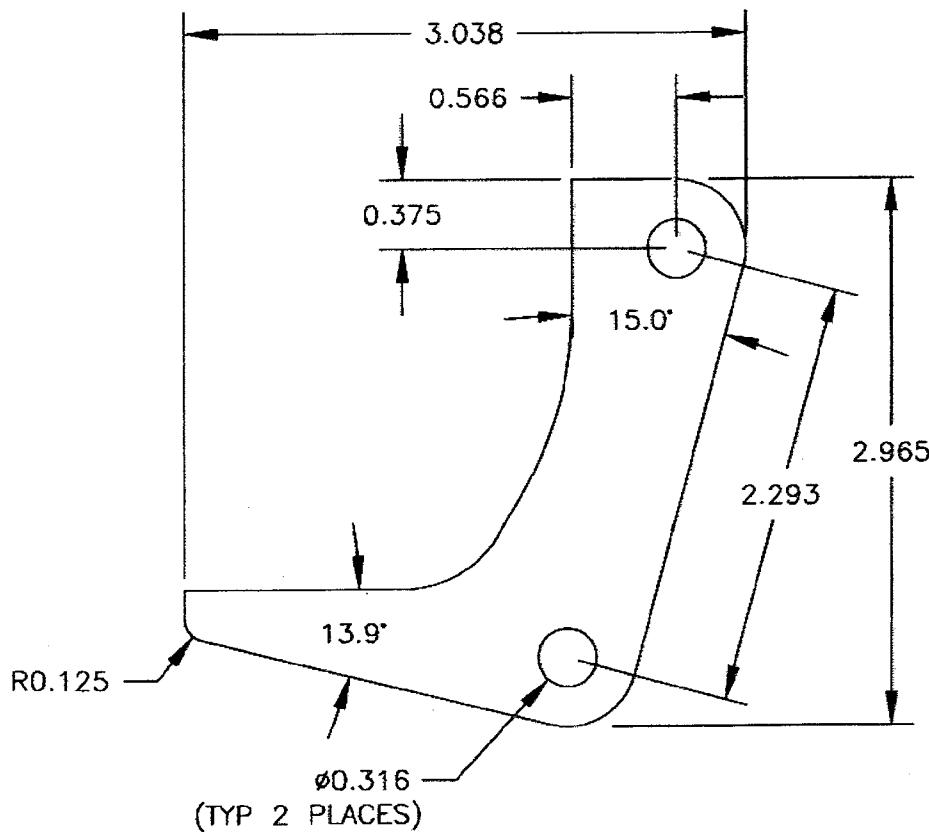
X First Article Prototype

Measured by: <u>HB</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: 8-3-31	Date: 08/09/02	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	JK

DARTCOPY
DATE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3219
DATE		REV. A SHEET 1 OF 1
03.10.10		SCALE 1:1
A	03.10.10	NEW ISSUE

RELEASEDD3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRPT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

u/o 38252

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